Dart Aerospace Ltd. Tuesday, 30/09/2008 8:54:28 AM Date: Julie Lecocq User: **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : DOUBLER Customer Job Number : 42347 **Estimate Number** : 11169 Part Number : D32831 P.O. Number : D3283 REV E : 30/09/2008 S.O. No. : **Drawing Number** This Issue : N/A : NC **Project Number** Prsht Rev. : E : // : SMALL /MED FAB **Drawing Revision** Type First Issue : 39163 Material Previous Run : 15/10/2008 Qty: 30 Um: **Due Date** Written By **Checked & Approved By** New issue KJ/JLM Comment : Est A 04.09.28 Est Rev:B Now on Waterjet 07-05-28 JLM 07-09-09 JLM Est Rev:C As per Rev E Verified By:EC Additional Product Job Number: **Description:** Seq. #: **Machine Or Operation:** 6061-T6 .063 Sheet 1.0 M6061T6S063 Comment: Qty.: 0.2479 sf(s)/Unit Total: 7.4372 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3283-1 Batch: (08) WATER JET FLOW WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3283 Dwg Rev: 🏗 Prog Rev: E 2-Deburr if necessary HB 8-9-30 INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0

UB 8-9-30



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK 4.0



Comment: SECOND CHECK



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Dart Aeı	ospace	e Ltd									
W/O:			WO	WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE CHAN	ANGE By			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQA</b> :		_ Date: _	~		
	R	esolution:	Disposition	:	QA: N/C Cld	sed:	<del></del>	Date:			
NCR:			VORK ORDE	R NON-CONFORMA	NCE (NCR	)					
DATE	0750	Description of NC	(	Corrective Action Section		Verifica	ition	Approval	Approval		
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NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:28 AM Julie Lecocq .User: **Process Sheet** Drawing Name: DOUBLER Customer: CU-DAR001 Dart Helicopters Services Part Number: D32831 Job Number: 42347 Job Number: Seq. #: Description: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 7.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE PACKAGING 1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ FINAL INSPECTION/W/O RELEASE QC21 10.0 Comment: FINAL INSPECTION/W/O RELEASE U 08110-03 Job Completion

## **Dart Aerospace Ltd**

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:PAR #:		PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
		esolution:	Disposition	_ QA: N/C Closed:			Date:		
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	OTED	Description of NC	Corrective Action		on B	Verific	cation	Approval	Approval
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42347	7
Description: Doubler	Part Number: D3283-1	
Inspection Dwg: D3283 Rev: E	Page 1 of	1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.750	+/-0.010	14.750	*	,		
10.634	+/-0.010	10,634	)so			
1.250	+/-0.010	1.249	×ŧ			
1.250	+/-0.010	1.251	<b>X</b>			
1.500	+/-0.010	1,497	×			
3.000	+/-0.010	2.994	*			
1.170	+/-0.010	1.177	*		-	
0.710	+/-0.010	714	×			
0.250	+/-0.010	.25	¥			
1.420	+/-0.010	1,423	×			
Ø0.500	+0.006/-0.001	102,	X			,
Ø0.129	+0.005/-0.001	.131	×			
						<u> </u>
		·				

Measured by:	B	Audited by:	· .	Prototype Approval:	N/A
Date:	8-9-36	Date: Of	109/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.11.23	New Issue	KJ/JLM	
В	07.06.04	Dimensions updated per Dwg Rev. D	KJ/JLM	
С	07.09.26	Dwg Rev updated	KJ/EC	B

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	DESIGN	DRAWN BY	DART ACROCACE LICA INIC
	41	20	PORT HADLOCK, WA
	CHECKED	APPROVED,	DRAWING NO. REV. E
	The state of the s	*	D3283 SHEET 1 OF 2
	DATE		TITLE SCALE
	07.06.01		DOUBLER 1:3
	Α	04.05.06	NEW ISSUE
	В	04.08.09	10.882 WAS 11.502
	C	05.03.16	CHANGE HOLE PATTERN FOR -1
	D	05.08.09	REDESIGN
	E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)
6			

	14.750 —		
1.250	DRILL #30 (Ø0.129 REF) (TYP 57 PLACES)	3.000	R0.06 (TYP)
1.170 0.710 0.250 0.000			<del></del> Ç 1.420
NO.—SECRETARY ORDER MADES OF THE STREET TO WENDWEN COD ENGINEERING	2.825 3.196 - 3.196 - 3.942 - 4.317 4.692 5.067 5.817 6.192 - 6.192 - 6.567 6.942 - 7.317 6.92 - 6.942 - 7.317 6.92 - 6.942 - 7.317 6.92 - 6.942 - 7.317 6.9	9.567 9.567 9.567 10.309 10.959 11.809 12.459 13.309 13.959 14.500	

## D3283-1 DOUBLER

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- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DRAWING NO. D3283

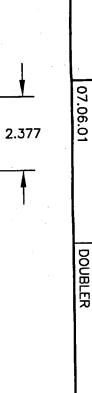
SHEET 2 OF 2

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- MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
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- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED